Date: Tuesday, 23/09/2008 10:22:33 AM
User: Julie Lecocq

# Process Sheet

| | | | |
|---|---|---|---|
| **Customer** | : CU-DAR001 Dart Helicopters Services | **Drawing Name** | : WEARSHOE |
| **Job Number** | : 42233 | | |
| **Estimate Number** | : 12736 | | |
| **P.O. Number** | : | **Part Number** | : D353515 |
| **This Issue** | : 23/09/2008 **S.O. No.** : | **Drawing Number** | : D3535 REV B |
| **Prsht Rev.** | : NC | **Project Number** | : N/A |
| **First Issue** | : / / **Type** : SMALL /MED FAB | **Drawing Revision** | : B |
| **Previous Run** | : 37810 | **Material** | : |
| **Written By** | : | **Due Date** | : 05/10/2008 **Qty:** 12 **Um:** Each |
| **Checked & Approved By** | : JLM 08.9.23 | | |
| **Comment** | : Est Rev:A New Issue 07-02-15 JLM | | |
| | Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC | | |

**Additional Product**

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 1.0 | M304S20GA | 304/316 .040 Sheet |

**Comment:** Qty.: 1 sf(s)/Unit Total : 13 sf(s)
304/316 .040 Sheet
(M304S20GA)
Batch: 109088 HB 8-10-9

| | | |
|---|---|---|
| 2.0 | WATER JET | FLOW WATER JET |

**Comment:** FLOW WATER JET
1-Cut as per Dwg D3535
Dwg Rev: B
Prog Rev: B
HB 8-10-9
13

2-Deburr if necessary HB 8-10-9

| | | |
|---|---|---|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |

HB 8-10-9

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|---|---|---|
| 4.0 | QC8 | SECOND CHECK |

**Comment:** SECOND CHECK
Solution (13)

| | | |
|---|---|---|
| 5.0 | BRAKE NC | NC BRAKE |

**Comment:** NC BRAKE
1-Form on Brake as per Dwg D3535 using Jigs DT8261and DT8326
2-Form joggle as per Dwg D3535 using Jig DT8158
3-Identify as D3535-15
08/10/14 (13)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

Date: Tuesday, 23/09/2008 10:22:33 AM
User: Julie Lecocq

# Process Sheet

**Customer:** CU-DAR001 Dart Helicopters Services **Drawing Name:** WEARSHOE

**Job Number:** 42233 **Part Number:** D353515

Job Number:

| Seq. #: | Machine Or Operation: | Description : |
|---|---|---|
| 6.0 | QC5 | INSPECT WORK TO CURRENT STEP |

**Comment:** INSPECT WORK TO CURRENT STEP

08/10/14 x13

| | | |
|---|---|---|
| 7.0 | POWDER COATING | POWDER COATING |

M 106442 13X

**Comment:** POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 10:30
OVEN TEMPERATURE: 320°F
FINISH TIME: 11:00

M.L 08/10/15

| | | |
|---|---|---|
| 8.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |

13

**Comment:** INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/10/15

| | | |
|---|---|---|
| 9.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |

**Comment:** PACKAGING RESOURCE #1
Identify and Stock
Location: FP/8

FL 08/10/15 13

| | | |
|---|---|---|
| 10.0 | QC21 | FINAL INSPECTION/W/O RELEASE |

08/10/16 KH

**Comment:** FINAL INSPECTION/W/O RELEASE

Job Completion

h 08.10.15



Form: rprocess

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **PROCEDURE CHANGE** | **By** | **Date** | **Qty** | **Approval** Chief Eng / Prod Mgr | **Approval** QC Inspector |
| | | | | | | | |
| | | | | | | | |

**Part No:** _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

**Resolution:** _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|---|---|---|---|---|---|---|---|---|
| **DATE** | **STEP** | **Description of NC** Section A | **Corrective Action** Section B | | | **Verification** Section C | **Approval** Chief Eng | **Approval** QC Inspector |
| | | | **Initial** Chief Eng | **Action Description** Chief Eng | **Sign & Date** | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

**NOTE:** Date & initial all entries

| DART AEROSPACE LTD | Work Order: | 42233 |
|---|---|---|
| | | |
| **Description:** Wearshoe | Part Number: | D3535-15 |
| | | |
| **Inspection Dwg:** D3535 **Rev:** B | | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|---|---|---|---|---|---|---|
| 1.885 | +/-0.010 | 1.893 | X | | | |
| 2.000 | +/-0.010 | 2.000 | X | | | |
| 5.650 | +/-0.010 | 5.652 | X | | | |
| 9.150 | +/-0.010 | 9.146 | X | | | |
| 14.400 | +/-0.010 | 14.400 | X | | | |
| 19.650 | +/-0.010 | 19.650 | X | | | |
| 24.900 | +/-0.010 | 24.906 | X | | | |
| 30.150 | +/-0.010 | 30.156 | X | | | |
| 33.650 | +/-0.010 | 33.650 | X | | | |
| 35.650 | +/-0.010 | 35.650 | X | | | |
| 39.150 | +/-0.010 | 39.150 | X | | | |
| Ø0.188 | +0.005/-0.001 | .1190 | X | | | |
| 24.00 | +/-0.030 | 24.00 | X | | | |
| 16.00 | +/-0.030 | 16.00 | X | | | |
| 8.00 | +/-0.030 | 8.00 | X | | | |
| 5.00 | +/-0.030 | 5.00 | X | | | |
| 0.300 | +/-0.010 | .304 | X | | | |
| 0.300 | +/-0.010 | .303 | X | | | |
| 0.038 | +/-0.010 | .038 | X | | | |
| | | | | | | |
| | | | | | | |

| Measured by: | JB |
|---|---|
| Date: | 8-10-09 |

| Audited by: | S |
|---|---|
| Date: | 08/10/09 |

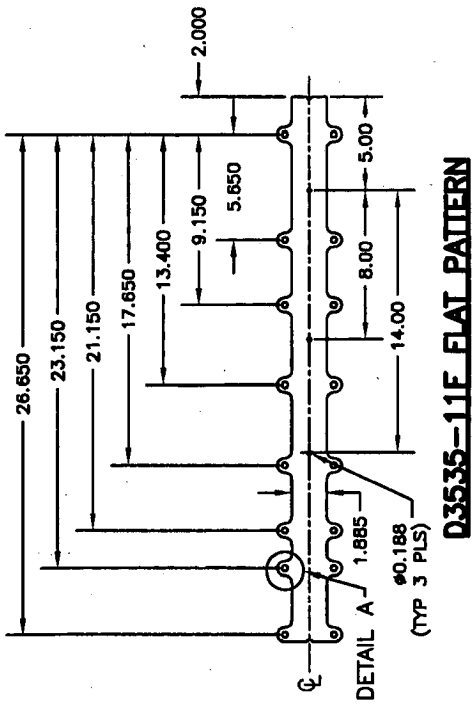
| Prototype Approval: | N/A |
|---|---|
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|---|---|---|---|---|
| A | 07.05.10 | New Issue | KJ/JLM | |

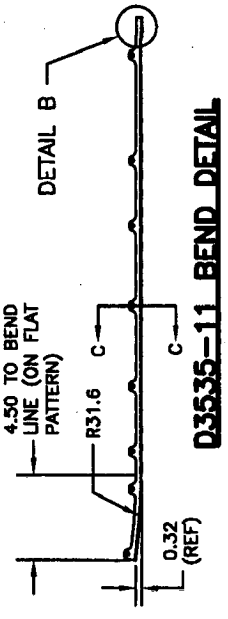
| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. |
|---|---|---|
| CB | PH | PORT HADLOCK, WA |
| CHECKED | APPROVED | DRAWING NO. REV. B |
| | | D3535 SHEET 1 OF 7 |
| DATE | | TITLE SCALE |
| 07.04.17 | | WEARSHOE 1:10 |

| | | |
|---|---|---|
| A | 06.10.25 | NEW ISSUE |
| B | 07.04.17 | MOVE TAB OUTBOARD, ADD AMS SPEC |

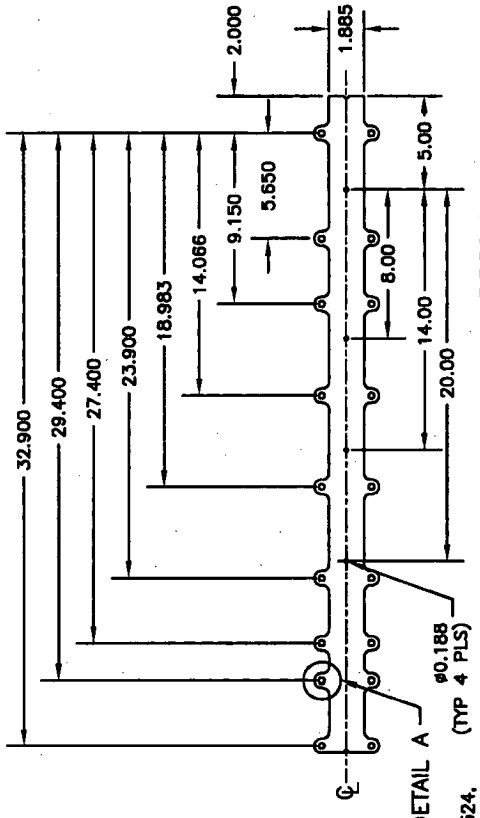
RELEASED
07.04.24



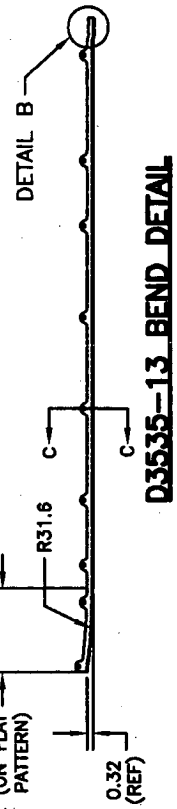

D3535-11F FLAT PATTERN




D3535-11 BEND DETAIL




D3535-13F FLAT PATTERN




D3535-13 BEND DETAIL

SHOP COPY
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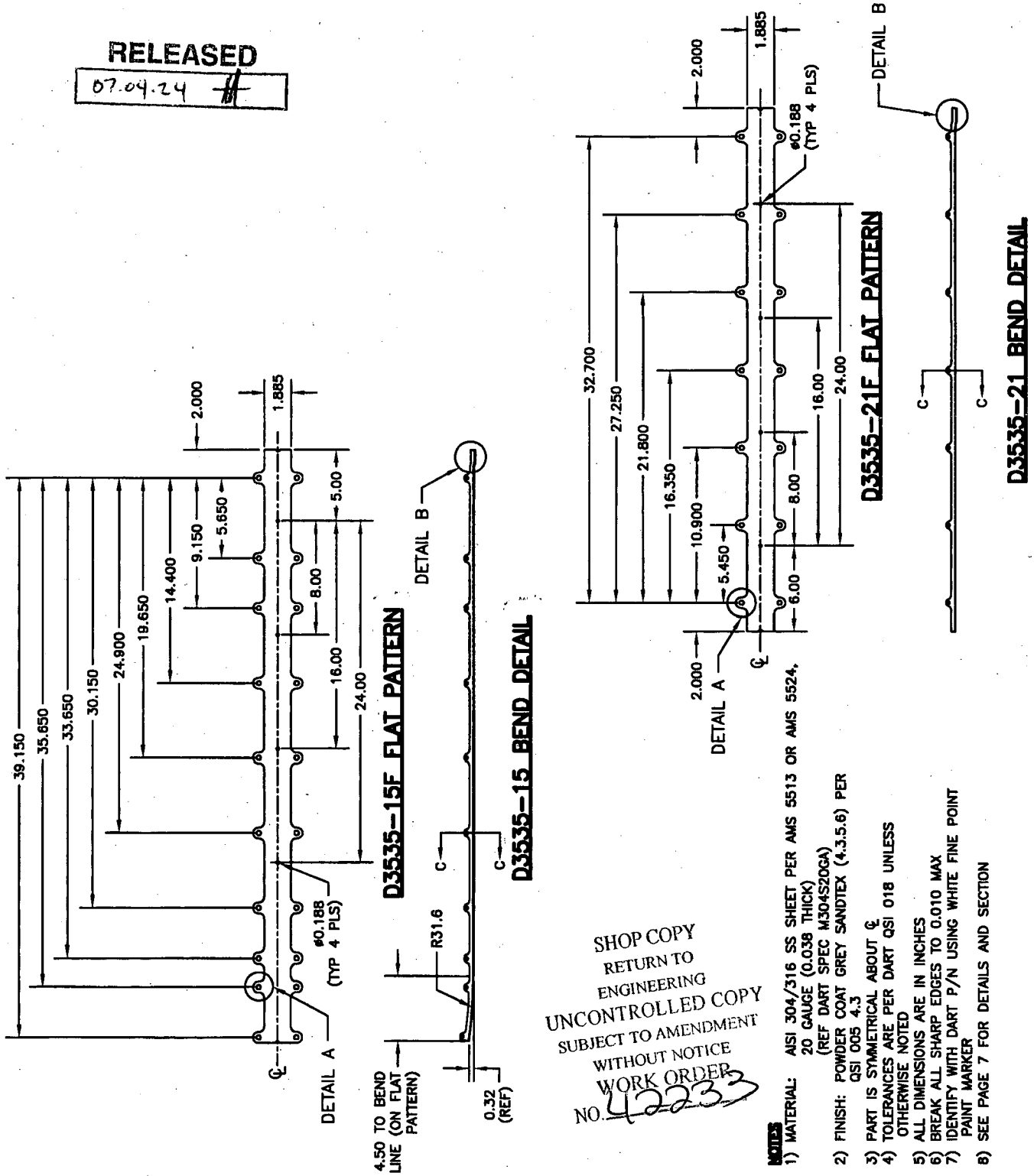
WITHOUT NOTICE
WORK ORDER
NO. 122333

NOTES:
1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
3) PART IS SYMMETRICAL ABOUT ℄
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES TO 0.010 MAX
7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
8) SEE PAGE 7 FOR DETAILS AND SECTION

| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. |
|---|---|---|
| CB | PH | PORT HADLOCK, WA |
| CHECKED | APPROVED | DRAWING NO. / REV. |
| | | D3535 / B |
| DATE | TITLE | SHEET 2 OF 7 / SCALE |
| 07.04.17 | WEARSHOE | 1:10 |

RELEASED
07.04.24

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NO. 42233

NOTES
1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER (REF DART SPEC M304S20GA) QSI 005 4.3
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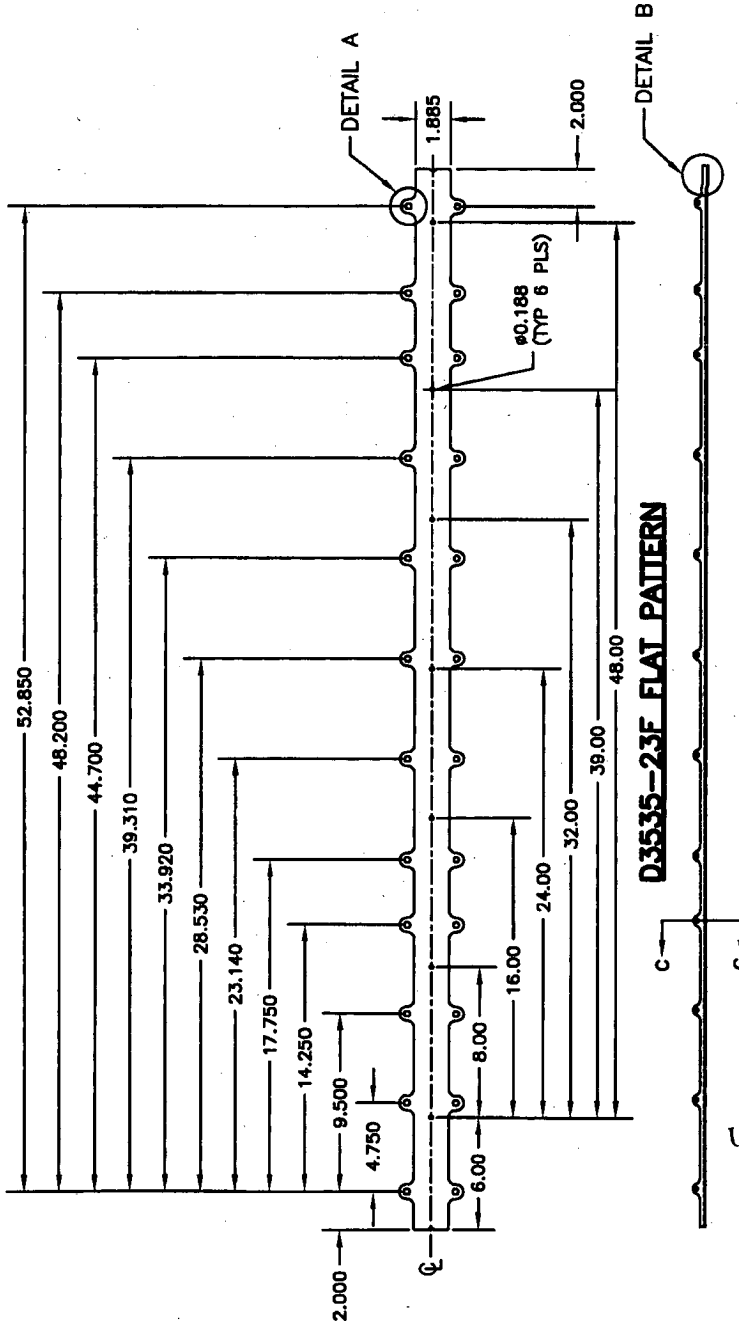
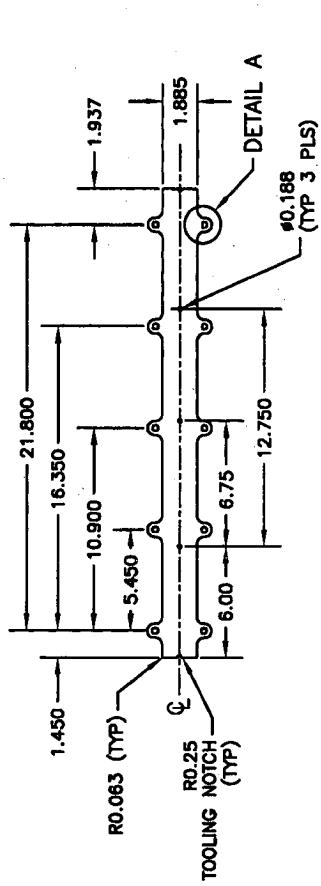
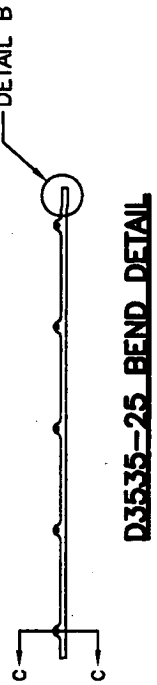
| CB | PH | PORT HADLOCK, WA |
| CHECKED | APPROVED | DRAWING NO. D3535 — REV. B — SHEET 3 OF 7 |
| DATE 07.04.17 | TITLE WEARSHOE | SCALE 1:10 |

RELEASED
07 04.24

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NO. 92233

**NOTES**
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8) SEE PAGE 7 FOR DETAILS AND SECTION

## D3535-31F FLAT PATTERN




## D3535-31 BEND DETAIL

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07.04.24

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WORK ORDER NO. 42233




## D3535-33F FLAT PATTERN




## D3535-33 BEND DETAIL

**NOTES**

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
8) SEE PAGE 7 FOR DETAILS AND SECTION

DART

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| C.B | PH | PORT HADLOCK, WA | |
| CHECKED | APPROVED | DRAWING NO. | REV. B |
| | | D3535 | SHEET 4 OF 7 |
| DATE | | TITLE | SCALE |
| 07.04.17 | | WEARSHOE | 1:10 |

| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
|---|---|---|---|
| CB | PH | | |
| CHECKED | APPROVED | DRAWING NO. D3535 | REV. B SHEET 5 OF 7 |
| DATE 07.04.17 | | TITLE WEARSHOE | SCALE 1:10 |

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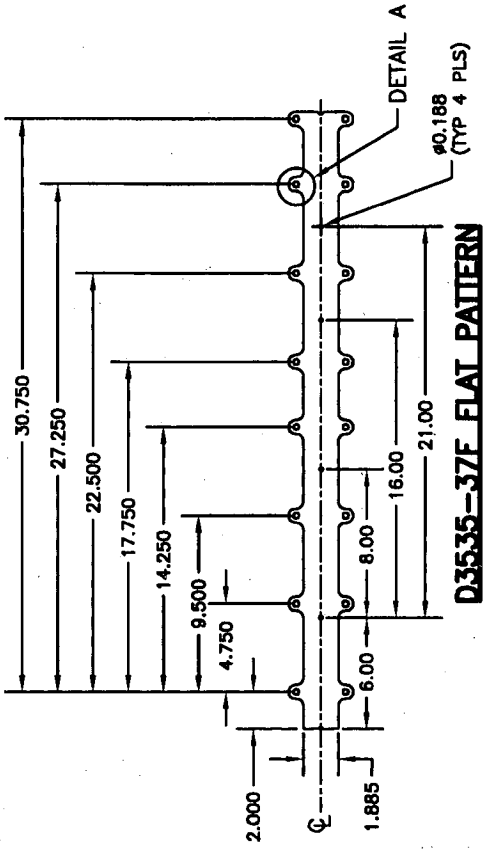
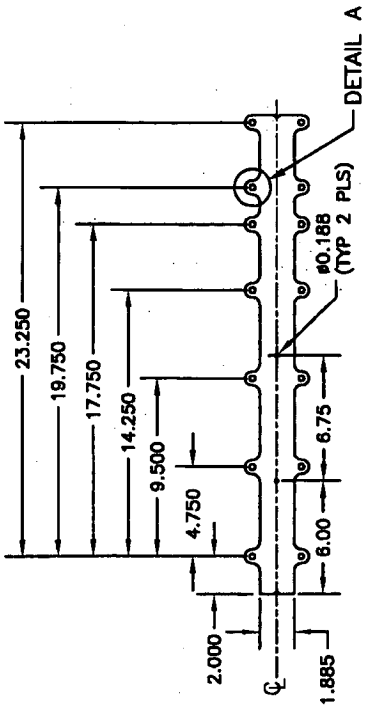
07.04.24




D3535-37F FLAT PATTERN

D3535-37 BEND DETAIL

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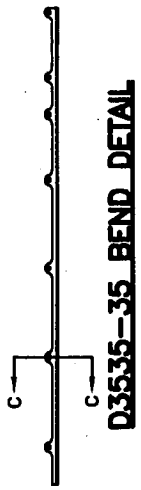


D3535-35 BEND DETAIL

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NOTES
1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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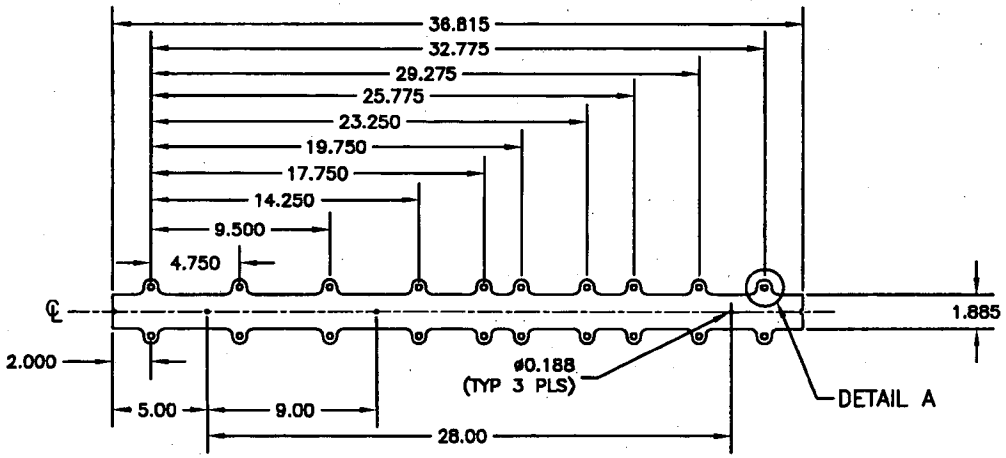
7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
8) SEE PAGE 7 FOR DETAILS AND SECTION




## D3535-39F FLAT PATTERN

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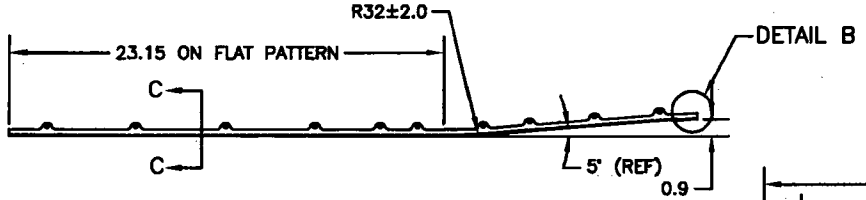
07.04.24




## D3535-39 BEND DETAIL

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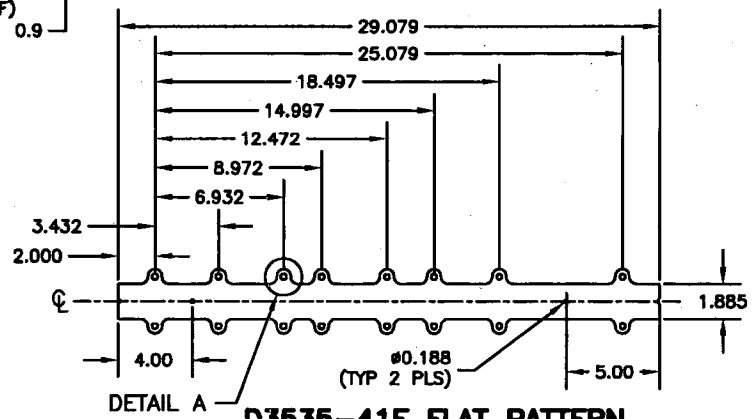
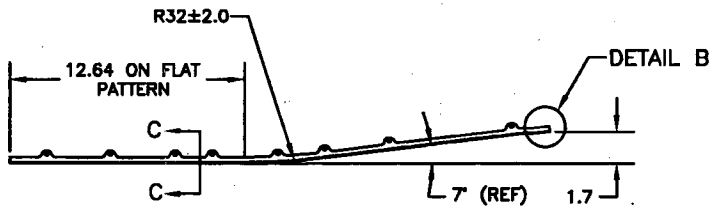



## D3535-41F FLAT PATTERN




## D3535-41 BEND DETAIL

**NOTES**

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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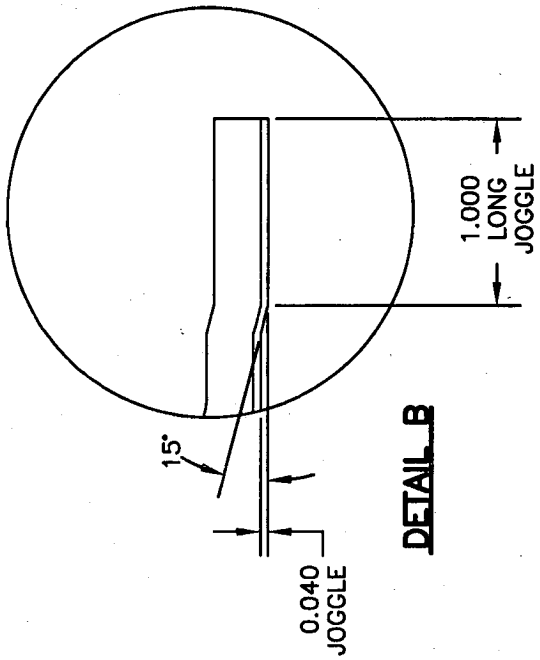
8) SEE PAGE 7 FOR DETAILS AND SECTION

DART

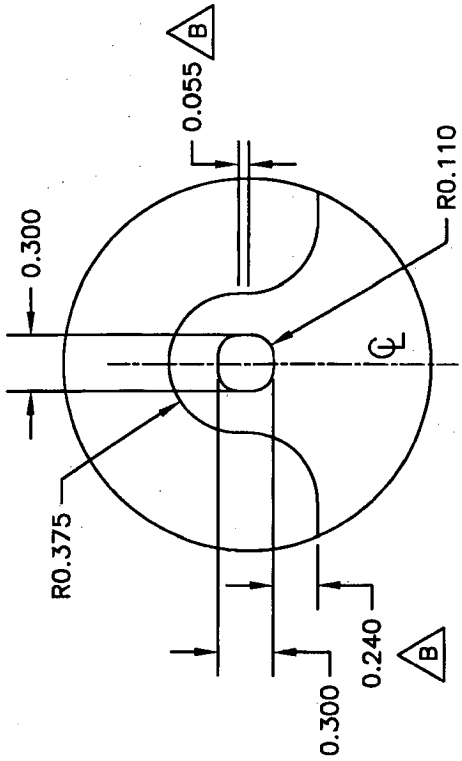
| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. | |
|---|---|---|---|
| C.B | PH | PORT HADLOCK, WA | |
| CHECKED | APPROVED | DRAWING NO. | REV. B |
| | | D3535 | SHEET 6 OF 7 |
| DATE | | TITLE | SCALE |
| 07.04.17 | | WEARSHOE | 1:10 |

| DESIGN | DRAWN BY | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
|---|---|---|---|
| CB | PH | | |
| CHECKED | APPROVED | DRAWING NO. D3535 | REV. B SHEET 7 OF 7 |
| DATE 07.04.17 | | TITLE WEARSHOE | SCALE 1:1 |

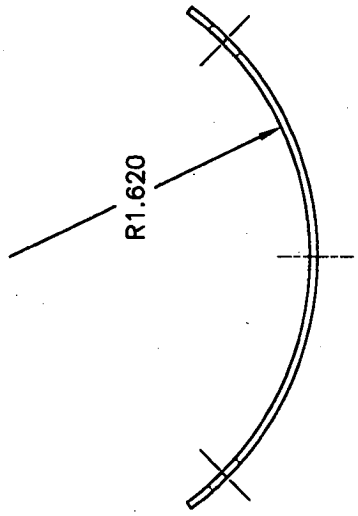
RELEASED
07.04.24




DETAIL B




DETAIL A




SECTION C–C

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WORK ORDER
NO. 42233